

Date: Wednesday, 1/11/2006 4:10:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FLOAT STEP
Job Number	: 23321		
Estimate Number	: 10850		
P.O. Number	: N/A	Part Number	: D206628024
This Issue	: 1/11/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25435	Drawing Revision	: N/A
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/30/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	2 Um: Each
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-024 CHG 002

DH 06/02/14

(2)

2.0	23321A	206B FLOAT STEP ASSY, RH
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Comment: Sub-Component D2842-042 Sub-Assembly
 FLOAT STEP ASSEMBLY LH (206/407)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2731-7	Mounting Lug	B2B331 ✓

5.0	D28441	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2844-1	Arm	B22593 2m4 B22332 2m4 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:10:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 23321

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2844-3 Arm B14087 ✓

7.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2660 f(s)/Unit Total: 2.5320 f(s)

Pick:

Qty Part # Description Batch

2 D2856-400 6.9" Abrasion Strip B24237B ✓

8.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 LUG ASS,Y B25408 ✓

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3C4A Bolt M19522

10.0

AN4C12A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4C12A Bolt M19600

11.0

AN4C13A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4C13A Bolt M19600

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 23321

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M1799

13.0

AN960C10



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 6.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

M18728

14.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L

Washer

M100229

15.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L

Washer

M18918

16.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4

Nut (or MS21042-4)

M18535

17.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3

Washer

M17944

Rec'd 3/9 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: SD Date: 26/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:10:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 23321

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CL 06/03/10

(2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-024

Location: _____

PPP Rev: _____

F

PC 6/3/14

(2)

20.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/03/15

(2)

Job Completion



W 06.03.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Float Step RH (206L/L1/L3/L4)		Part Number:	D206-628-024
Dwg:		Qty:	
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																																								
1	DC	Issue Travelers for: D206-628-024 Float Step RH D2842-042 Step Assembly RH																																																											
2	DC	Photocopy bluefile and create labels per PPP D206-628-024 CHG001																																																											
3	ST	Pick: Packing Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>D2731-5</td><td>Mounting Lug</td><td></td></tr><tr><td>4</td><td>D2731-7</td><td>Mounting Lug</td><td></td></tr><tr><td>1</td><td>D2842-042</td><td>Step Assembly RH</td><td></td></tr><tr><td>2</td><td>D2844-1</td><td>Arm</td><td></td></tr><tr><td>1</td><td>D2844-3</td><td>Arm</td><td></td></tr><tr><td>3</td><td>AN3-4A</td><td>Bolt</td><td></td></tr><tr><td>4</td><td>AN4-11A</td><td>Bolt</td><td></td></tr><tr><td>4</td><td>AN4-12A</td><td>Bolt</td><td></td></tr><tr><td>4</td><td>AN4-13A</td><td>Bolt</td><td></td></tr><tr><td>3</td><td>AN960JD10</td><td>Washer</td><td></td></tr><tr><td>12</td><td>AN960JD416</td><td>Washer</td><td></td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td></td></tr><tr><td>1</td><td colspan="2">Copy of paperwork from step 2</td><td></td></tr></table>	Qty	Part Number	Description	Batch	4	D2731-5	Mounting Lug		4	D2731-7	Mounting Lug		1	D2842-042	Step Assembly RH		2	D2844-1	Arm		1	D2844-3	Arm		3	AN3-4A	Bolt		4	AN4-11A	Bolt		4	AN4-12A	Bolt		4	AN4-13A	Bolt		3	AN960JD10	Washer		12	AN960JD416	Washer		12	MS21042L4	Nut (or -4)		1	Copy of paperwork from step 2					
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4	QC4	Inspect Kit 100% for Completeness on the W/O																																																											
5	PK	Identify and pack for shipping as per PPP D206-628-024																																																											
6	AC	Cost / part: _____																																																											
7	DC	Close W/Order and Ensure Travellers Attached Inspect Level 21 Travellers: D206-628-024 D2842-042																																																											

Rev	Date	Change	Revised By	Approved
A	99.05.05	New Issue	DM	
B	04.05.17	Reformat; Added D2842-042 as traveler	KJ/JLM	

REFERENCE ONLY